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**D3067-1**  
**Job Sheet 182272**



Part No: D3067-1

Job Qty: 150 ea

Part Name: End Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/21/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP: 03.01.21 Remove step 6 (Deburr) KJ IPP Rev:B Now on Water jet 06-06-16 JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty     | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|--------------------|---------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                    |         |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 90    | Start up Operation | 150 Ea  | 8/31/18    | 8/31/18  | 0.00      | 0.00    | Start Up Waterjet     |           | ac 18/08/22 |
| 100   | Waterjet           | 150 pcs | 8/31/18    | 8/31/18  | 0.00      | 1.99    | Waterjet1             |           | ac 18/08/22 |
| 120   | QC                 | 150 pcs | 8/31/18    | 8/31/18  | 0.00      | 0.00    | QC8                   |           | 38          |
| 130   | Brake NC           | 150 pcs | 8/31/18    | 8/31/18  | 0.00      | 1.19    | Brake NC 1            |           | DA-89 38    |
| 140   | QC                 | 150 pcs | 8/31/18    | 8/31/18  | 0.00      | 0.00    | QC5                   |           | 38          |
| 150   | Packaging          | 150 pcs | 8/31/18    | 8/31/18  | 0.00      | 0.00    | Packaging3 Large Fab  |           | 9-89        |
| 160   | QC21-SA            | 150 Ea  | 8/31/18    | 8/31/18  | 0.00      | 0.00    | QC21                  |           | cm 18.09.06 |

Part Op 100 - 1-Cut as per Dwg D3067

Descriptions: 130 - Bend as per Dwg D3067

150 - \*\*\* STOCK IN STEP CELL\*\*\*

### Job BOM

| Part / Item   | Component Name      | Quantity             | Operation             | Container |
|---------------|---------------------|----------------------|-----------------------|-----------|
| M5052H32S.063 | 5052-H32 .063 Sheet | 9.3750 sf (.0625 ea) | 90-Start up Operation |           |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | M5052H32S.063  | 9        | 34        | 0         |

### Part Specifications

| Spec No | Description | Target/Tolerance        | Limits         | Type | Special Comments |
|---------|-------------|-------------------------|----------------|------|------------------|
| 1       | End Plate   | 2.900inches $\pm$ 0.010 | 2.910<br>2.890 |      |                  |
| 2       | End Plate   | 2.749inches $\pm$ 0.010 | 2.759<br>2.739 |      |                  |

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                                                                     |                    |                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                       |                                                                                |                                                     |
|-----------------------------------------------------------------------------------------------------|--------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------|-----------------------------------------------------|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____<br><br>Date : _____<br><br>Desc: _____ | <b>DISPOSITION</b> | <b>AGAINST DEPARTMENT/PROCESS</b>                                                                                                                                                                                                                                                                                                                       |                                                                                                                                       |                                                                                |                                                     |
|                                                                                                     |                    | <input type="checkbox"/> Solid tube<br><input type="checkbox"/> Cross tube                                                                                                                                                                                                                                                                              | <input type="checkbox"/> Water Jet<br><input type="checkbox"/> Prod. Eng. Coord.<br><input type="checkbox"/> Store/Packaging Supplier | <input type="checkbox"/> Engineering Quality<br><input type="checkbox"/> Other |                                                     |
|                                                                                                     |                    |  <p>           Part: D3067-1<br/>           Job No: 182272<br/>           Serial No/Batch: S104284<br/>           Revision:<br/>           Inspector:<br/>           Exp Date:<br/>           Instructions: Various STC's<br/>           Date: 08/22/18         </p> |                                                                                                                                       |                                                                                | <b>MRB (QSI042) Approval</b>                        |
|                                                                                                     |                    |                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                       |                                                                                | <b>Completed By</b>                                 |
|                                                                                                     |                    |                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                       |                                                                                | <b>Lead hand / Supervisor Approval Verification</b> |
|                                                                                                     |                    |                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                       |                                                                                | <b>QC / QA Coordinator Approval</b>                 |

  

| Root Cause         |                          |                       |                          |                        |                          |                                   |                          |                       |                          |                      |                          |
|--------------------|--------------------------|-----------------------|--------------------------|------------------------|--------------------------|-----------------------------------|--------------------------|-----------------------|--------------------------|----------------------|--------------------------|
| Environment        | <input type="checkbox"/> | No Re-verification    | <input type="checkbox"/> | Pressure/Forced        | <input type="checkbox"/> | Temperature/Cure                  | <input type="checkbox"/> | Power Loss/Surge      | <input type="checkbox"/> | Positioned Wrong     | <input type="checkbox"/> |
| Design             | <input type="checkbox"/> | Operator              | <input type="checkbox"/> | Bending                | <input type="checkbox"/> | Set-up                            | <input type="checkbox"/> | Folio/Program         | <input type="checkbox"/> | Outside Dimensions   | <input type="checkbox"/> |
| Doc/Data           | <input type="checkbox"/> | Offset/Setup          | <input type="checkbox"/> | Centre Not Concentric  | <input type="checkbox"/> | BOM/Route                         | <input type="checkbox"/> | Grain                 | <input type="checkbox"/> | Over/Under tolerance | <input type="checkbox"/> |
| Equip/Tooling      | <input type="checkbox"/> | Supplier              | <input type="checkbox"/> | Cracks                 | <input type="checkbox"/> | Broken/Damage/Defect              | <input type="checkbox"/> | Weld                  | <input type="checkbox"/> | Part Incorrect       | <input type="checkbox"/> |
| Handling/Pre       | <input type="checkbox"/> | Training              | <input type="checkbox"/> | Crimp/Kink/Ripple/Wave | <input type="checkbox"/> | Inspection Incomplete/Unqualified | <input type="checkbox"/> | Wrong Stock Pulled    | <input type="checkbox"/> | Part Lost/Missing    | <input type="checkbox"/> |
| Material           | <input type="checkbox"/> | Use for Testing       | <input type="checkbox"/> | Cuffs                  | <input type="checkbox"/> | Contamination                     | <input type="checkbox"/> | Out of Sequence       | <input type="checkbox"/> | Part Moved           | <input type="checkbox"/> |
| Internal Transport | <input type="checkbox"/> | Poor Information      | <input type="checkbox"/> | Crushing               | <input type="checkbox"/> | Countersink                       | <input type="checkbox"/> | Off-set               | <input type="checkbox"/> | Drawing              | <input type="checkbox"/> |
| Tribal Knowledge   | <input type="checkbox"/> | Rushing               | <input type="checkbox"/> | Heat Treat             | <input type="checkbox"/> | Cut Too Short                     | <input type="checkbox"/> | Mislabeled            | <input type="checkbox"/> | Finish               | <input type="checkbox"/> |
| LOA                | <input type="checkbox"/> | Product Improvement   | <input type="checkbox"/> | Wave/Twist in Tube     | <input type="checkbox"/> | Instructions Incomplete/Unclear   | <input type="checkbox"/> | Fit/Function          | <input type="checkbox"/> | Misread              | <input type="checkbox"/> |
| Substation         | <input type="checkbox"/> | Process Improvement   | <input type="checkbox"/> | Marks/Chatter          | <input type="checkbox"/> | Drill Holes                       | <input type="checkbox"/> | Misaligned/off center | <input type="checkbox"/> | Turning Sequence     | <input type="checkbox"/> |
| Past Expiry Date   | <input type="checkbox"/> | Manufacturing Process | <input type="checkbox"/> | OTHER :                |                          |                                   |                          |                       |                          |                      |                          |
| Misidentified      | <input type="checkbox"/> | Past Due              | <input type="checkbox"/> |                        |                          |                                   |                          |                       |                          |                      |                          |